

Work Order ID 64868

Monday, December 20, 2010 2:42:19 PM

Page 1

Item ID: D4291-1

Accept

Revision ID:

Item Name: Spacer

Start Date: 12/20/2010 Start Qty: 100.00

Required Date: 12/30/2010 Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4291

A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB026 & DWG FOLIO REV: _____

DWG REV: _____

2-DEBURR AS REQUIRED

11/01/04

102

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/01/04

102

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11.1.4

102

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Item ID: D4291-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 12/20/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 12/30/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

102 BR 11-01-5

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

27 M 11/01/05

102 d

150

Identify as per dwg & Stock Location: 139B

0.00



Packaging

Memo

0.00

Packaging

CC 11/01/06 (102)

Work Order ID 64868

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Monday, December 20, 2010 2:42:19 PM

Item ID: D4291-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 12/20/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 12/30/2010 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/06

MF
11-01-06

Picklist Print

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Page 1

Work Order ID: 64868



Parent Item: D4291-1



Parent Item Name: Spacer

Start Date: 12/20/2010

Required Date: 12/30/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A 10.112.20 new issue DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6R0.375

Purchased

No

100

f

34.2500

0.104

10.94737



11/20/104

6061-T6 Round Bar .375"

Location

Loc Qty

Loc Code

MAT012

34.25

112567

34.25

11.8 A1

10ft

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

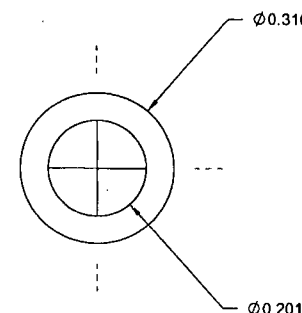
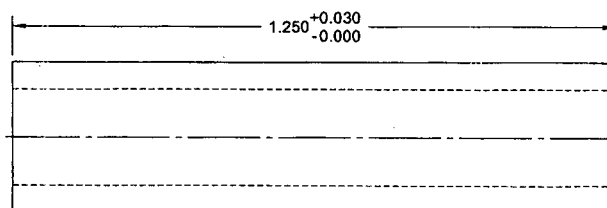
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4486*

pk 12-20



D4291-1 SPACER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

RELEASED
2010-11-04
MP

| | | | |
|------------|--------------------|--|--------------|
| A | NEW ISSUE | SC | 10.11.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | SC | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D4291 | SHEET 1 OF 1 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACER | NTS |
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